Date: Tuesday, 15/07/2008 4:12:03 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Job Number	: 40517		
Estimate Number	: 10534		
P.O. Number	:	**Part Number**	: D2574
This Issue	: 15/07/2008 **S.O. No.** :	**Drawing Number**	: D2574 REV E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : MACHINED PARTS	**Drawing Revision**	: E
Previous Run	: 40199	**Material**	:
Written By	:	**Due Date**	: 08/08/2008 **Qty:** 10 **Um:** Each
Checked & Approved By	: JLD 08.7.16		
Comment	: Est Rev: I As Per RevE 06-01-27 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	Saddle Billet

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2574
Ensure that grain is along 5.00" length
Batch No: B34874 08/08/16 10

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. 40517 Double check by: N.A

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

J.F. 08/08/20 (10)

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE

Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574 J.F. 08/08/20 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE J.F. 08/08/20 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Date: Tuesday, 15/07/2008 4:12:03 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 40517 **Part Number:** D2574

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK	28 07/08/20
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	MZ/M.L 08/08/20 (NIO)
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 9:20 OVEN TEMPERATURE: 320 of FINISH TIME: 9:50	M108523 (10X) M.L 08/08/21
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	08-08-21 (V10)
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST 433	CL 08/08/21 (10)
10.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08/08/21 MF 08-08-21

Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	40517
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	**1**	**2**	**3**	**4**	**By**	**Date**
A	0.438	0.443		.440	.440	.446	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.006	8.000	8.000	8.000		
F	0.490	0.510		.500	.505	.506	.504		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.502	.502	.501		
J	1.174	1.184		1.179	1.180	1.179	1.180		
K	0.558	0.578		.568	.570	.570	.569		
L	1.174	1.184		1.179	1.180	1.179	1.180		
M	1.365	1.375		1.369	1.370	1.370	1.370		
N	2.495	2.505		2.499	2.500	2.499	2.499		
O	4.119	4.129		4.121	4.123	4.125	4.125		
P	0.115	0.135		.127	.126	.127	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.257	.252	.257		
S	0.115	0.135		.120	.127	.127	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.229	3.230	3.230	3.230		
V	0.230	0.250		.240	.246	.239	.240		
W	0.115	0.135		.127	.132	.132	.131		
X	0.307	0.312		.307	.308	.307	.307		
Y	0.760	0.765		.760	.761	.760	.760		
Z	0.352	0.372		.366	.366	.359	.365		
AA	0.470	0.530		.500	.506	.500	.500		
AB	0.615	0.635		.626	.626	.626	.627		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.244	.247	.246	.247		
AE	1.500	1.520		1.510	1.510	1.500	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.265	.265	.262	.262		
AH	0.240	0.260		.249	.250	.250	.249		
AI	2.000	2.020		2.000	2.002	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	
Date:	08/08/18

Audited by	
Date:	08/28/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40517
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	**Min**	**Max**	**Go/No Go Gauge**	#5	#6	#7	#8	**By**	**Date**
A	0.438	0.443		.440	Ø.439"	Ø.439"	Ø.439"		
B	1.745	1.755		1.750	1.750"	1.750"	1.750"		
C	3.495	3.505		3.500	3.501"	3.501"	3.501"		
D	1.745	1.755		1.750	1.750"	1.750"	1.750"		
E	7.990	8.010		8.000	8.004"	8.004"	8.004"		
F	0.490	0.510		.502	.503"	.502"	.505"		
G	0.257	0.262		.260	.260	.260	Ø.258"		
H	0.375	0.380		.378	.378	.378	Ø.377"		
I	0.490	0.510		.502	.502	.501	.505"		
J	1.174	1.184		1.179	1.180	1.179	1.179"		
K	0.558	0.578		.571	.570	.569	.569"		
L	1.174	1.184		1.179	1.180	1.179	1.179"		
M	1.365	1.375		1.369	1.369	1.370	1.370"		
N	2.495	2.505		2.499	2.506	2.506	2.500"		
O	4.119	4.129		4.124	4.122	4.123	4.123"		
P	0.115	0.135		.127	.127	.127	.126"		
Q	0.115	0.135		.135	.135	.135	.135"		
R	0.240	0.260		.252	.251	.251	.252"		
S	0.115	0.135		.128	.127	.128	.126"		
T	0.178	0.198		.188	.188	.188	.188"		
U	3.210	3.250		3.230	3.228	3.229	3.230"		
V	0.230	0.250		.239	.239	.239	.239"		
W	0.115	0.135		.132	.130"	.130"	.130"		
X	0.307	0.312		.308	.308"	.308"	.309"		
Y	0.760	0.765		.760	.760"	.761	.761"		
Z	0.352	0.372		.361	.364"	.362"	.365"		
AA	0.470	0.530		.500	R.500"	R.500"	R.500"		
AB	0.615	0.635		.628	.629"	.630"	.630"		
AC	0.053	0.073		.063	.063"	.063"	.063"		
AD	0.240	0.260		.248	.247	.247	.250"		
AE	1.500	1.520		1.571	1.570	1.571	1.510"		
AF	0.115	0.135		.135	.135	.135	.135"		
AG	0.240	0.280		.266	.268	.268	.280"		
AH	0.240	0.260		.249	.249	.249	.251"		
AI	2.000	2.020		2.002	2.003	2.001	2.001"		
AJ	0.023	0.043		.033"	.033"	.033"	.033"		
Accept/Reject									

Measured by:	J.F.
Date:	08/08/18

Audited by	
Date:	08/28/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	40517
Description: Saddle, Aft Inboard	Part Number:	D2574
Inspection Dwg: D2574 Rev. E		Page 1 of 1

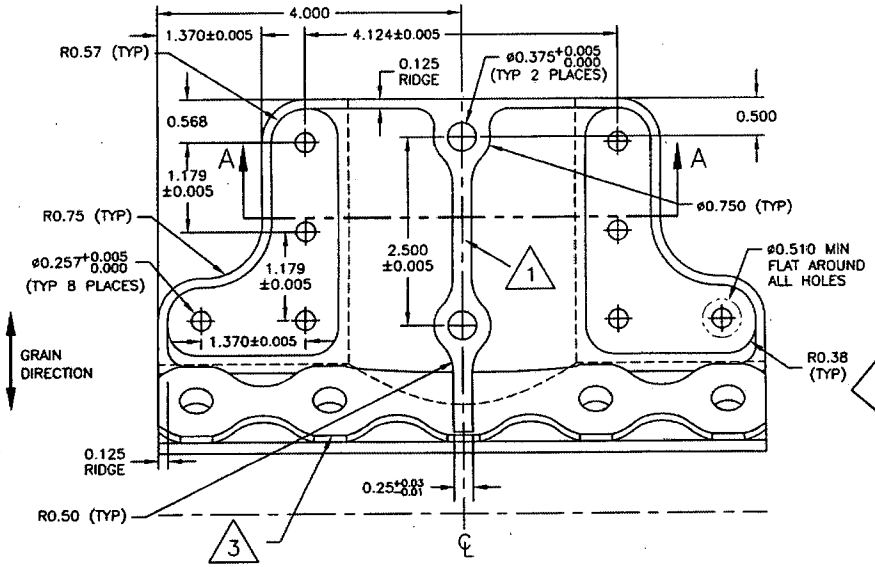
Inspect dimensions highlighted on inspection sheet drawing D2574 Rev. E and record below:

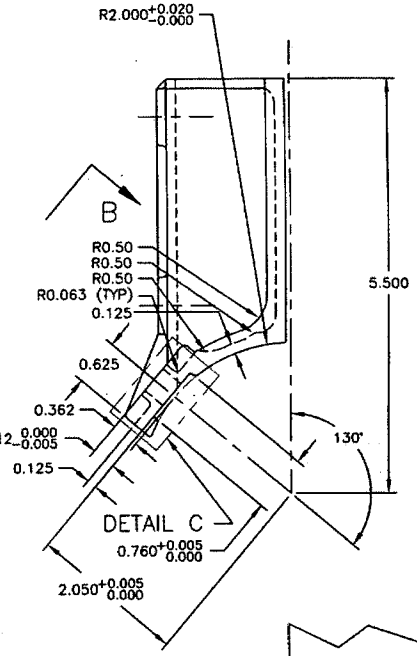
				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	~~19~~ 10	~~20~~ 12	3	4	By	Date
A	0.438	0.443		Ø.439"	Ø.439"				
B	1.745	1.755		1.750"	1.750"				
C	3.495	3.505		3.501"	3.501"				
D	1.745	1.755		1.750"	1.750"				
E	7.990	8.010		8.004"	8.004"				
F	0.490	0.510		.503"	.503"				
G	0.257	0.262		Ø.258"	Ø.258"				
H	0.375	0.380		Ø.377"	Ø.377"				
I	0.490	0.510		.504"	.503"				
J	1.174	1.184		1.179"	1.179"				
K	0.558	0.578		.572"	.569"				
L	1.174	1.184		1.179"	1.179"				
M	1.365	1.375		1.370"	1.370"				
N	2.495	2.505		2.500"	2.500"				
O	4.119	4.129		4.123"	4.123"				
P	0.115	0.135		.126"	.126"				
Q	0.115	0.135		.135"	.135"				
R	0.240	0.260		.252"	.252"				
S	0.115	0.135		.127"	.125"				
T	0.178	0.198		R.188"	R.188"				
U	3.210	3.250		3.230"	3.230"				
V	0.230	0.250		.239"	.237"				
W	0.115	0.135		.131"	.130"				
X	0.307	0.312		.310"	.310"				
Y	0.760	0.765		.761"	.761"				
Z	0.352	0.372		.367"	.367"				
AA	0.470	0.530		R.500"	R.500"				
AB	0.615	0.635		.630"	.629"				
AC	0.053	0.073		.063"	.063"				
AD	0.240	0.260		.250"	.250"				
AE	1.500	1.520		1.511"	1.511"				
AF	0.115	0.135		.135"	.135"				
AG	0.240	0.280		.280"	.280"				
AH	0.240	0.260		.251"	.251"				
AI	2.000	2.020		2.011"	2.001"				
AJ	0.023	0.043		.033"	.033"				
Accept/Reject									

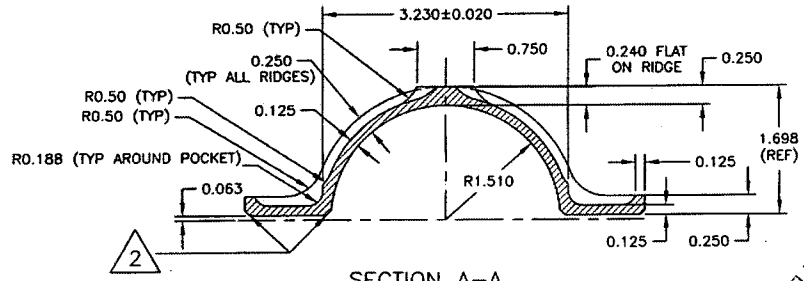
Measured by:	J.F.
Date:	08/08/19

Audited by	SP
Date:	08/08/20

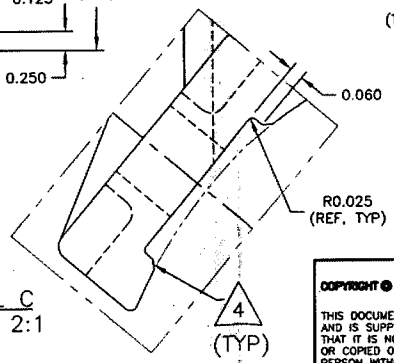
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.27	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



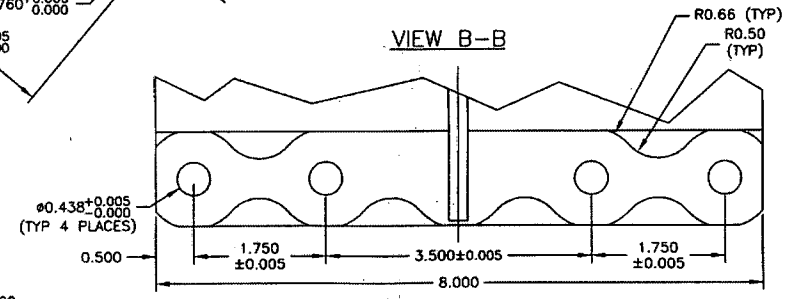




SECTION A–A



DETAIL C
SCALE 2:1



RELEASED
05.2.06

NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

1. ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
2. CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
3. CHAMFER 0.063 x 45° ALL AROUND
4. CHAMFER 0.033 x 45° (SEE DETAIL C) E

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
DS	PH	
CHECKED	APPROVED	DRAWING NO. D2574 — REV. E — SHEET 1 OF 1
DATE 05.07.13		TITLE: INNER AFT SADDLE — SCALE 2:3